

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000427**Date Inspected:** 25-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Lefeng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** N/A**Summary of Items Observed:**

The CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication of the Mock-up 77 meters elevation scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge. ZPMC welder operator Xue Yi An was observed by the QA Inspector performing welding operations on the shop splice at the skin panel E weld joint # 1 and 2 following the approved welding procedure specification WPS-B-T-2321-B-P3-S. The base metal was designated as A-709 Grade 50. ZPMC was using the submerged arc welding (SAW) process in the flat (1G) position with the 4.8 mm diameter designated as EM12K/AWS A5.17, brand name JW-3. The QA Inspector verified amperages, voltages, preheat and heat interpass temperatures. The QA inspector found that the welding parameters reported by Xu Lefeng approved ZPMC Certified Welder Inspector appeared to be in accordance with the contract documents.

On this date, ZPMC was observed removing run-on tabs on the skin plate B & D and grinding temporary attachments at the skin panel # C.

The photos below show ZPMC performing dimensional inspections to the skin panel B and the skin panel E weld splice side # 1 that was being welded on this date.

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Summary of Conversations:

The QA inspector did not have any relevant conversations on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Acuna,Alfredo

Quality Assurance Inspector

Reviewed By: Cuellar,Robert

QA Reviewer